

Work Order ID 64399

Friday, December 03, 2010 3:09:59 PM

Page 2

Item ID: D4107-7

Accept

Revision ID:

Item Name: Ball Stud Spacer

Start Date: 12/3/2010 Start Qty: 12.00

Required Date: 12/17/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 123

0.00



Packaging

Memo

0.00

Packaging

10/12/13 SP (120)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/12/13
MF
10-12-13

Picklist Print

Friday, December 03, 2010 3:10:04 PM

Page 1

Work Order ID: 64399

Parent Item: D4107-7

Parent Item Name: Ball Stud Spacer



Start Date: 12/3/2010

Required Date: 12/17/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 10-09-24 JLM VERIFIED BY:DD IPP
Rev:B 10.12.03 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303R0.500

Purchased

No

100

f

15.4670

0.05

0.631579



303 Round Bar 0.500"



5/10/12/09

Location

Loc Qty

Loc Code

MAT

13.467

114852

9.2

115593

4.267

MAT028

2

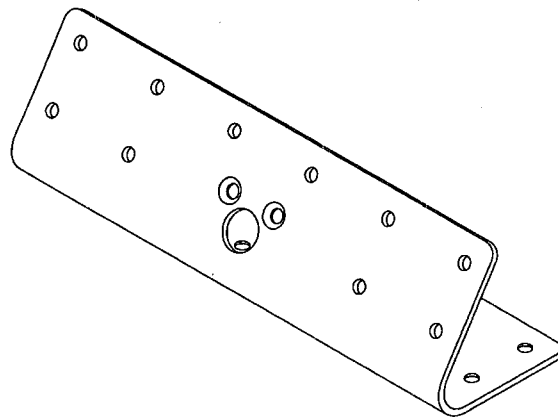
112567

2

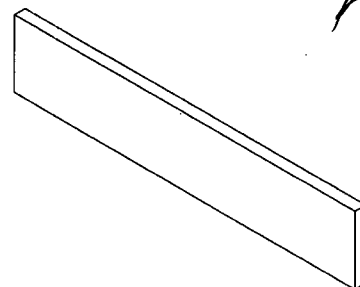
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. 72 RF

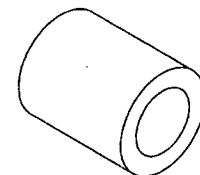
SHOP COPY
 RETURN TO
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 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 49399
P/10-12-3



D4107-1 DOOR DOUBLER







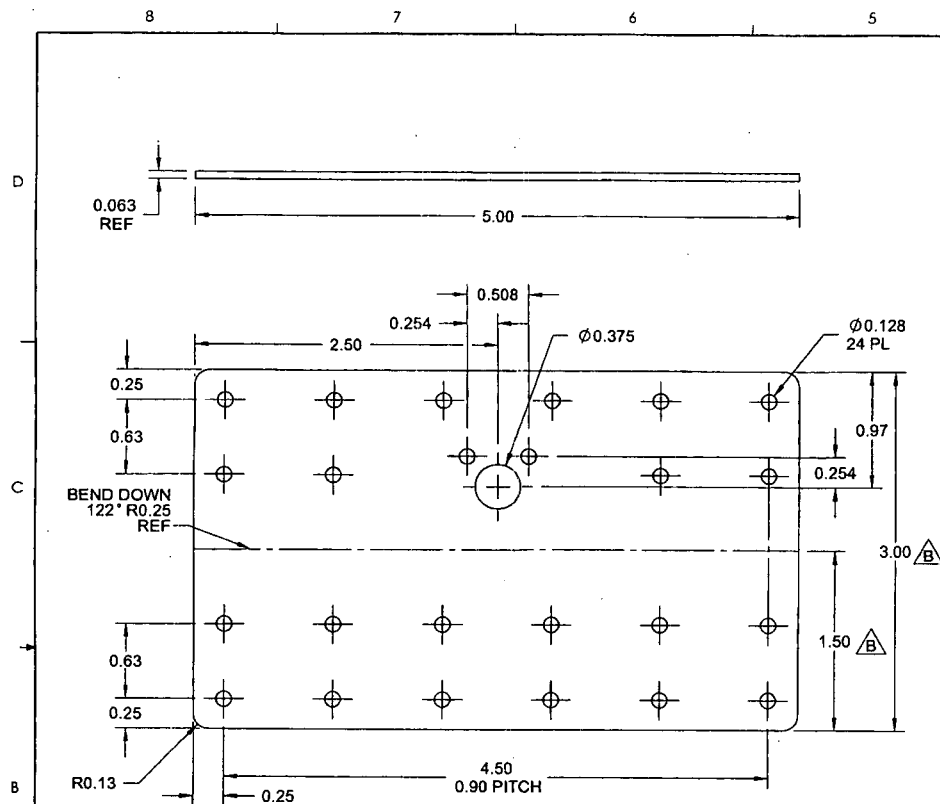
D4107-5 SPACER



D4107-7 BALL STUD SPACER

RELEASED
 2010-11-30

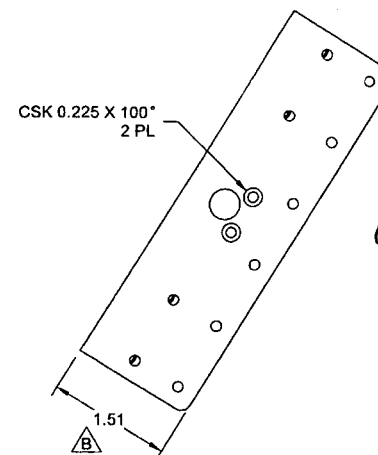
B	D4107: DIM 3.00 WAS 3.20 & 1.50 WAS 1.60 (ZN C5-2); 1.51 WAS 1.61 (ZN B2-2 & C3-2) TO IMPROVE INSTALLATION		JPH	10.11.01
A	NEW ISSUE		JPH	10.07.15
REV.	DESCRIPTION		BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED			DRAWING NO.	REV. B
MFG. APPR.			D4107	SHEET 1 OF 3
APPROVED			TITLE	SCALE
DE APPR.		DOUBLER & SPACERS	NTS	
DATE	10.11.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>		



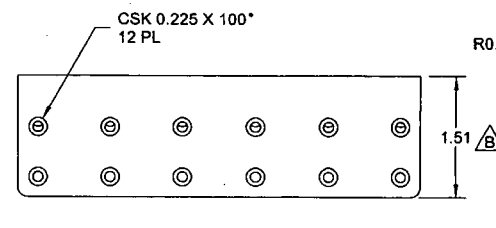
D4107-1F FLAT PATTERN, DOOR DOUBLER

NOTES:

- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
-1: MAKE FROM D4107-1F.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -1: IDENT P/N D4107-1 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs



VIEW A-A

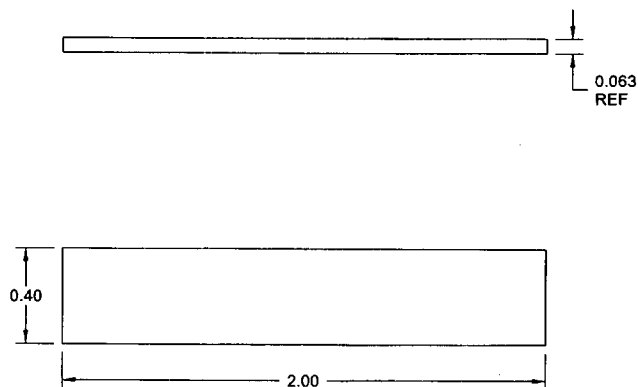


**D4107-1 DOOR DOUBLER
(MAKE FROM D4107-1F)**

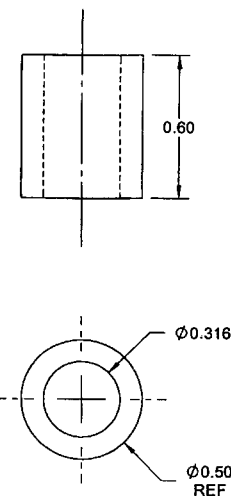
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2010-11-30
JPH

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CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4107	SHEET 2 OF 3
APPROVED	JPH	TITLE	SCALE
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w/064329



D4107-5 SPACER



D4107-7 BALL STUD SPACER

NOTES:

- 1) MATERIAL -5: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S063
OR
ALUMINUM 2024-T3 SHEET 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 7: 303/304/316 STAINLESS STEEL ROUND BAR $\phi 0.50$, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R0.500 OR M304R0.500
- 2) FINISH -5: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-7: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4107-X & B/N PER QSI 044.
- 7) WEIGHT -5: < 0.01 lbs
-7: 0.03 lbs

RELEASED
2010-11-00

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER & SPACERS	NTS
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